

Date: Tuesday, 5/9/2006 9:17:28 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABLE GUARD
Job Number	: 27043		
Estimate Number	: 12410		
P.O. Number	: N/A	Part Number	: D34993
This Issue	: 5/9/2006 S.O. No. : N/A	Drawing Number	: D3499 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/16/2006 Qty: 10 Um: Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est Rev:A New Issue 06-05-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3499

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

MUHMMBIO 8100417



06-05-10 (10) ~~10~~

2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE



06/05/10 9

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment:

HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA636 Rev: AA & Dwg D3499 Rev: A

2-Deburr per dwg D3499

06/05/09 7 P10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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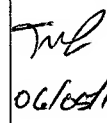

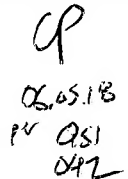
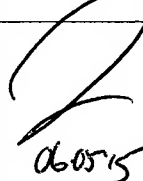
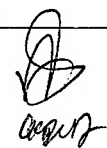
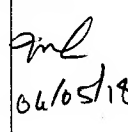
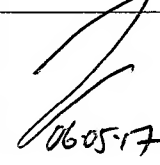
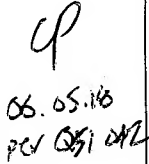
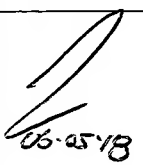



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



06/05/09 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.05.10	1.0	1 Scrap moved on machine, 1 cut too short, hole too close to edge.		2 Scrap & use Mat'l for tooling & identify.	 06/05/15	 06.05.15	 06.05.18 PCV QSI DAZ	 06.05.15
06.05.18	3.0	1 part all dimensions off by .050. in width & hole location. Off on set-up.		Scrap & destroy	 06/05/18	 06.05.17	 06.05.18 PCV QSI DAZ	 06.05.18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/05/23

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/9/2006 9:17:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27043

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



06-05-18

⑦

Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 06/05/23

⑦

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

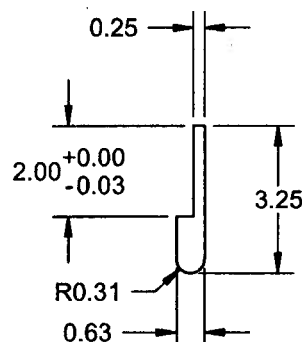
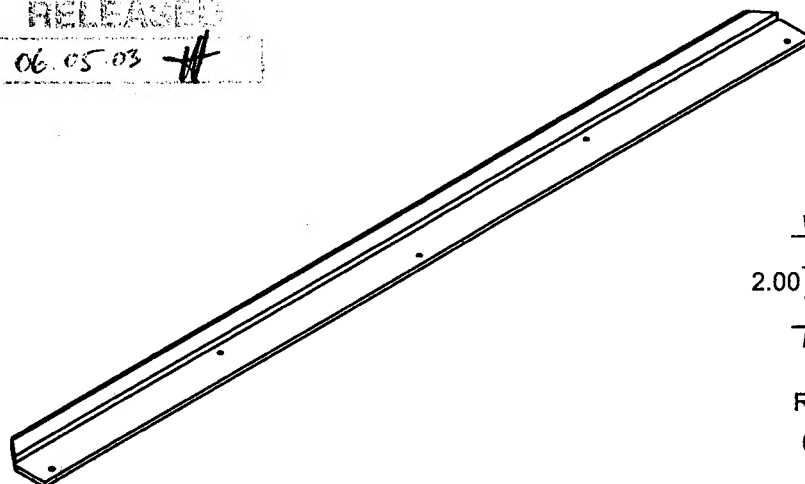
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

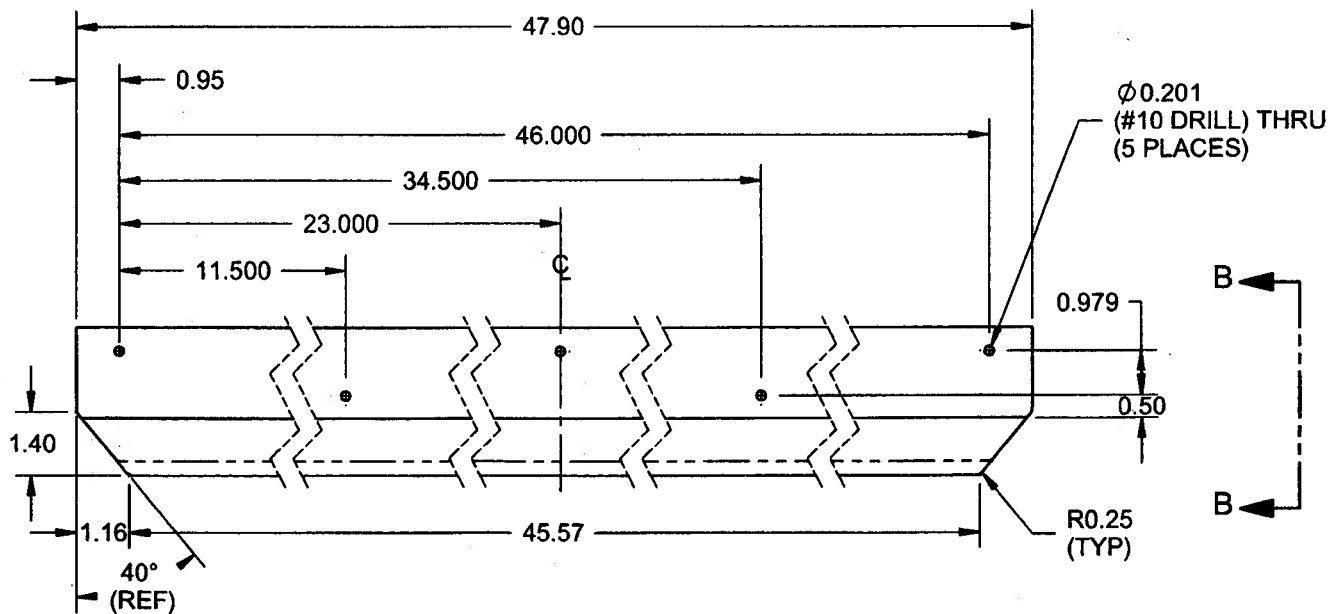


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. A SHEET 3 OF 4
DATE 06.04.11		TITLE CABLE GUARD	SCALE 1:4

RELEASED
06.05.03 *[Signature]*



VIEW B-B



D3499-3 CABLE GUARD

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

